



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4273-041
Job Sheet 177941



Part No: D4273-041

Job Qty: 1 ea

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 1,2,3,4,5 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/20/18	0.00	0.00	Start Up Large Fab-6		D.M.L 18-6-5
100	Large Fab	1 pcs		6/20/18	0.00	20.83	Large Fab 1		CPC
110	QC	1 pcs		6/20/18	0.00	0.00	QC9		D 18-06-08
120	QC	1 pcs		6/20/18	0.00	0.00	QC5		D 18-06-08
125	HandFinish	1 pcs		6/20/18	0.00	0.35	HandFinish2		D 18-6-13
130	Powdercoat	1 pcs		6/20/18	0.00	0.66	Powdercoat2		D 18-6-13
140	QC	1 pcs		6/20/18	0.00	0.00	QC3		D 18-6-13
150	Packaging	1 pcs		6/20/18	0.00	0.00	Packaging3-2		D 18-6-13
160	QC21-SA	1 Ea		6/20/18	0.00	0.00	QC21		D 18-6-13

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION E-E ON PAGE 2 DWG D4273, NEED Descriptions: TO WELDED AFTHER MESH IS INSTALL) weld as per dwg D4273 using DT10317 ***visual inspect before welding mesh*** 2- Cut D4279-1 base mesh (MADE ON THIS W/O) and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M/38839

START: 2:00

OUT: 3:30 FINISH: 2:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	SO54665
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	SO61862
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	SO58261
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	SO51952
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	SO66247
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	SO69386
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	SO62521 SO74862
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	SO58574
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	SO58263
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	SO72192
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	SO59496
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	SO59476
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	SO15962
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	SO92345
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	SO75248
D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation	SO17734

D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation
D4306-043	Rib Assembly, LH	1 Ea (1 ea)	90-Start up Operation
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation

↳ 5049915
 ↳ 5057508
 5024968
 5017134
 5037162
 5044670
 5054936
 5060244

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	75	0
	D3913-1	1	6	0
	D3913-15	1	18	0
	D3913-3	1	8	0
	D3913-9	1	11	0
	D3916-5	3	18	0
	D4016-1	3	13	0
	D4017-7	3	75	0
	D4021-1	3	70	0
	D4034-041	1	3	0
	D4277-19	1	1	0
	D4277-3	1	2	0
	D4277-5	2	4	0
	D4277-9	1	2	0
	D4278-045	2	0	0
	D4278-047	1	2	0
	D4279-5	1	6	0
	D4279-7	2	5	0
	D4279-9	1	2	0
	D4306-043	1	4	0
	D4306-045	1	6	0
	D4306-1	1	8	0
	D4672-1	2	32	0
	M304EX0.75-16F	32	1,603	0

Part Specifications

Specifications could not be found.

Master Unit 003412



Job No 177941



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Container No: S077942



Part: D4273-041

Job No: 177941

Serial No/Batch: S077942

Revision:

Inspector:

Exp Date: 06/05/2018

Instructions:

Date: 06/05/18